Work Order ID 60280

July 1, 2010 10:05:49 AM

Item ID:

D4051-7

Revision ID:

Start Date:

Reference:

Filler Item Name:

7/01/10

Start Qty: 2.00 Req'd Qty: 2.00

Required Date: 7/01/10

Approvals:

QC:

Process Plan:

a

Operation Description

Draw Nbr

Revision Nbr

D4051

Work Center ID

100

Sequence ID/

Waterjet

FLOW CNC Waterjet

304.063

Memo

1-Cut as per Qwg D4051

Dwg Rev:_ Prog Rev:_

2-Deburr if necessary

QC2- Inspect parts off machine FAI/FAIB

Memo

Date: 10/7/1

Date:

Accept

Tooling:

0.00

0.00

SPC (Y/N):

Set Up/

Run Hours



Setup Start

Stop



Cust Item ID:

Customer:

Date:

Date:

Run

Start

Stop



Tool ID

Tool # Plan

Qty Code

Accept

Reject Qty

Reject Number

Insp. Stamp

13(0-7-1

=7 Deburr M-/ 10/07/05 1810-71

0.00

Quality Control

110

QC

Work Order ID 60280

July 1, 2010 10:05:49 AM

Item ID:

D4051-7

Revision ID:

Item Name: Filler

Start Date:

7/01/10

Required Date: 7/01/10

Start Qty: 2.00

Req'd Qty: 2.00



Accept



Setup Start

Stop



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date: Date:

Start Run



Stop

Sequence ID/

Work Center ID

120

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/

Run Hours

0.00 2 whater

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Quality Control

130

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

Memo

0.00

0.00

140

Quality Control

QC21- Final Inspection - Work Order Release

0.00

MF -7-5

Picklist Print

July 1, 2010 10:05:48 AM

Work Order ID: 60280

D4051-7

Parent Item Name: Filler



Start Date: 7/01/10

Required Date: 7/01/10

Start Qty: 2.00

Required Qty: 2.00

Qty

Issued

Comments:

Parent Item:

IPP RevA: new issue DD 10.01.12 verified by:EC

dwg REV.A DD 10.02.22 verified by:EC

IPP Rev:B as per

Component Item ID/ Item Name

Replacement Mfg/ Item ID

Purch

Bin Primary Item Location

No

Last Location Route Seq ID Unit of Qty on Measure Hand

Qty per Kit Total

Qty

Date Issued

Status

M304S16GA

Purchased

100

sf

70.1439

0.0016 0.003368 HB10-7-1

304/316 Sheet .063

Location MAT

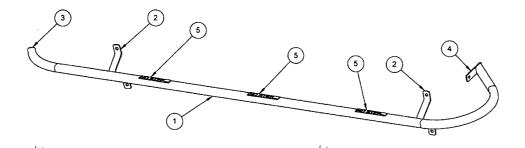
111323 114799

Loc Qty 70.14389474

70.1438947

Loc Code

TEM	QTY -041	QTY -042	P/N	DESCRIPTION
	Х		D4051-041	RAPPEL DEFLECTOR ASSY
		Х	D4051-042	RAPPEL DEFLECTOR ASSY
1	1	1	D4051-1	RAPPEL DEFLECTOR
2	-2	2	D4051-3	BRACKET
3	1	1	D4051-7	FILLER
4	1	1	D4051-5	MOUNTING PLATE
5	3	3	D4051-9	PLACARD

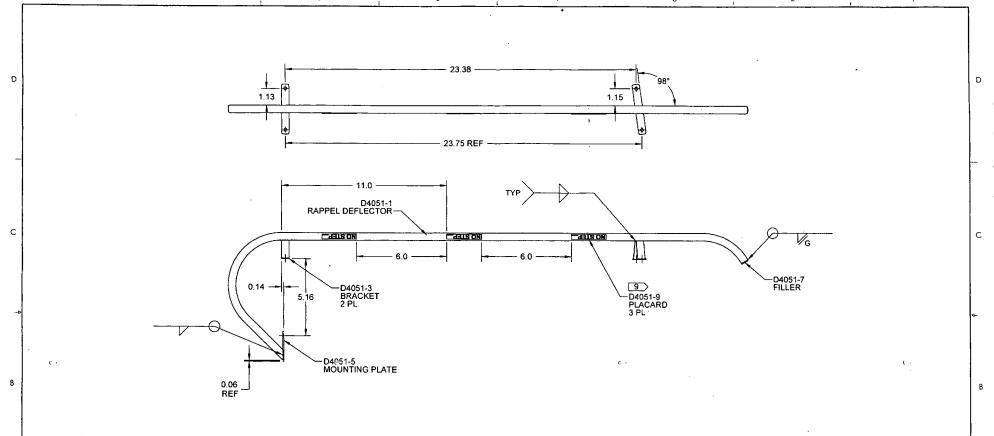


C210/19/01 210,60280

	T		····	RF		
Α	NEW IS	NEW ISSUE			10.01.29	
REV.	DESCRIPTION			BY	DATE	
DESIGN RF DRAWN RF		RF	DART AEROSPACE LTD			
		RF	HAWKESBURY, ONTARIO, CANADA			
CHECK	ŒD	D	DRAWING NO.		REV. A	
MFG. APPR.		17	D4051		SHEET 1 OF 7	
APPRO	VED	149	TITLE		SCALE	
DE APPR. ———————————————————————————————————		-#	RAPPEL DEFLECTOR ASSY			
		1.29	COPYRIGHT © 2010 BY DAF THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUF NOT TO BE USED FOR ANY PURPOSE OR ECOPE ON COUNTY WRITTEN PERMISSION FROM OA	PLED ON THE EXPRES	S CONDITION THAT IT IS	

2

8



D4051-041 RAPPEL DEFLECTOR ASSY

010:60280

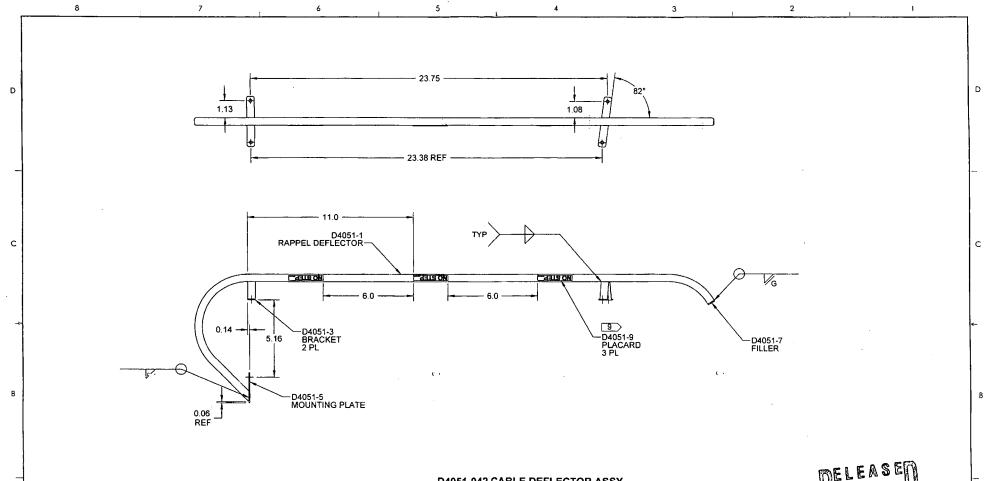
NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005.4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4051-041" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 1.07 ibs
8) WELD PER DART QSI 004
9) APPLY D4051-9 PLACARD AFTER POWDER COAT

8

DESIGN	RF	DART AEROSPACE LTD		
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA		
CHECKED	W	DRAWING NO. REV	. A	
MFG. APPR.	77	D4051 SHEET 2 C)F 7	
APPROVED	10	TITLE SCA	\LE	
DE APPR.	-#-	RAPPEL DEFLECTOR ASSY N	(TS	
DATE 10.01.29		COPYRIGHT © 2018 BY DART AEROSPACE LTD 148 DOCUMENT 6 PRIVATE AND CONTROL AND 5 EMPISSOR THE CONTROL THAT OF THE MOST THAT O		

3

2



D4051-042 CABLE DEFLECTOR ASSY

010.60280

NOTES:

1) MATERIAL: N/A

2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4051-042" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: 1.07 lbs

8) WELD PER DART QSI 004

9) APPLY D4051-9 PLACARD AFTER POWDER COAT

DESIGN RF DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D4051 MFG. APPR. SHEET 3 OF 7 APPROVED TITLE RAPPEL DEFLECTOR ASSY

COPYRIGHT © 2010 BY DART AEROSPACE LTD

THIS BOOLGENTS APPLANTS AND CONFIDENCE AUTOR SUPPLIED ON THE DARFASS COMMING TO THOSE USED OF AMERICAN FUNDAMENT CONFIDENCE AUTOR TO THE PURSON THE PURSON TO THE PURSON DE APPR. DATE 10.01.29

8

28.00 60° 135°±15° CLR3.25 TYP 8.53

8 D4051-1 RAPPEL DEFLECTOR

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 x 0.50 x 0.049 WALL REF DART SPEC. M304TS0.500W.049
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.98 lbs
8) TUBE FLAT LENGTH 43.00 REF

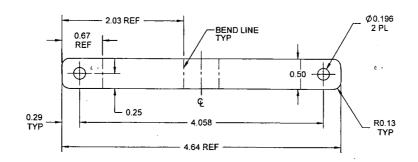
8

W10'. 60280

DESIGN	RF	DART AEROSPACE LTD
DRAWN RF		HAWKESBURY, ONTARIO, CANADA
CHECKED	W	DRAWING NO. REV. A
MFG. APPR.	17	D4051 SHEET 4 OF 7
APPROVED	NO.	TITLE SCALE
DE APPR.	#	RAPPEL DEFLECTOR ASSY NTS
DATE 10.01.29		THIS DOCUMENT IS PRIVATE AND COMPONENT AND IS SUPPLIED OF THE EXPRESS COMPONENT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPED OR COMPUTATIONAL TO THE ANY OTHER FERSON WITHOUT

0.63 - 1.35 R0.13 1.24 0.060 REF 0.69 TYP 3.33 REF

D4051-3 BRACKET (MAKE FROM D4051-3F FLAT PATTERN)



D4051-3F FLAT PATTERN

8

D

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 0.060 THICK ANNEALED 2B FINISH PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S16GA

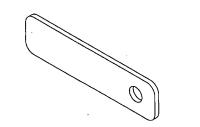
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.03 lbs

610:60280

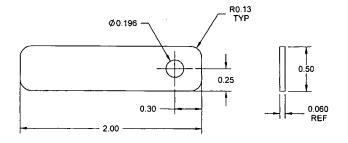
DESIGN RF		DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	9		V. A
MFG. APPR.	N	D4051 SHEET	OF 7
APPROVED	1A	TITLE	CALE
DE APPR.	#	RAPPEL DEFLECTOR ASSY	NTS
DATE 10.01.29		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND COMPONITY AND IS SUPPLED ON THE EXPRESS CONDITION THE NOT TO BE USED FOR AMP MANDESS OR COMPE ON COMMUNICATED TO ANY OTHER PRISON WITH	

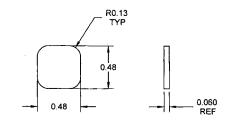
8

DI



D





D4051-5 MOUNTING PLATE

D4051-7 FILLER

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 0.060 THICK ANNEALED 2B FINISH PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S16GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: NONE 7) WEIGHT: D4051-5: 0.02 lbs D4051-7: 0.004 lbs

W10:60280

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	a	DRAWING NO. REV. A
MFG. APPR.	B	D4051 SHEET 6 OF 7
APPROVED	14	TITLE SCALE
DE APPR.	-#-	RAPPEL DEFLECTOR ASSY NTS
DATE 10.0)1.29	COPYRIGHT \$2.016 BY DART AEROSPACE LTD THIS DOCUMENT IS THINKED AND COMPONING AND ISSUED SO INTO EXPERTS DOMITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE ON COMED ON COMMINICATED TO ANY OTHER PERSON WITHOUT WITHOUT TO BE USED FOR ANY PURPOSE ON COMPANING AND TO THOSE PERSON WITHOUT WITHOUT THE PERSON FROM DART AND REPORT DATE TO THE PERSON WITHOUT WITHOUT THE PERSON FROM DATE TO THE PERSON FACE TO THE PERSON WITHOUT WITHOUT THE PERSON FROM DATE TO THE PERSON FACE TO THE PERSON WITHOUT THE PERSON FACE TO THE PERSON WITHOUT THE PERSON FACE TO THE PERSO

D

0.05

D4051-9 PLACARD



NOTES:
1) MATERIAL: RED LETTERS ON WHITE BACKGROUND AND SELF-ADHESIVE BACK.
MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: NONE
7) WEIGHT: N/A

010:60280

DESIGN	RF	DART AEROSPACE LTD		
DRAWN RF		HAWKESBURY, ONTARIO, CANADA		
CHECKED	a		EV. A	
MFG. APPR.	77	D4051 SHEET	7 OF 7	
APPROVED	143	TITLE	SCALE	
DE APPR.	#	RAPPEL DEFLECTOR ASSY	NTS	
DATE 10.01.29		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLED ON THE EXPRESS CONCINCION TO NOT TO BE USED FOR ANY PURPOSE OR COPED OR COMMUNICATED TO ANY OTHER PERSON WAS INSTRUMENT OF THE PRIVATE PERSON WAS INSTRUMENT OR THE PERSON WAS INSTRUMENT.		

DART AEROSPACE LTD	Work Order:	603 80
Description: FILLER	Part Number:	D4051-7
Inspection Dwg: D4o5)-7 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
,48	4-030	,48				
.48	4.03	.479				
. 063	7.00	100,				
				ļ		
				ļ		
			-			
			ļ			
				<u> </u>		
				 		
			 	-		
			<u> </u>	 		
					· · · · · · · · · · · · · · · · · · ·	
		<u> </u>		+		
	-		 	 		
				-		
			-	+		9,
		+				
		-		 		
			+	 		
					<u> </u>	

Managered by:	77	Audited by:	Prototype Approval:	N/A
Measured by:	B	<u> </u>	Date:	N/A
Date:	10-7-1	Date: 1407/05	Date.	

			Revise	d by	App	rove	d
Rev	Date	Change	KJ/JLN				
Α		New Issue	1 10,000				-